

Work Order ID 56249

Wednesday, February 17, 2010 11:03:21 AM



Page 1

Item ID: D2563

Revision ID:

Item Name: Step Weldment Assembly

Start Date: 2/18/2010 Start Qty: 4.00

Required Date: 3/4/2010 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2563

Rev C

100



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Debur ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

10-02-26

4 *Ø*

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

(x4)

Ø

3/10/2010

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sub 101

Memo

0.00

x6

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

10-03-01

Memo

0.00

4

4

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

10-03-2

Memo

0.00

4

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: *M111311*
Large Fab

Memo

0.00

1-Inspect for foreign object per QSI 024

2-Weld Remainig End cap as per Dwg D2563 using DT 8343

3-Grind

10.03.02

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*10.03.04**4**PD 10.03.04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

Touch up Alodine then
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:30am

320°

8:00am

0.00

10/03/04

(X4)

=)

10/03/08

(X4)

10/03/08

(X4)

10/03/08

(X4)

190



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch

M/13462

0.00

=)

10/03/08

(X4)

10/03/08

(X4)

Memo

0.00

10/03/08

(X4)

10/03/08

(X4)

10/03/08

(X4)

10/03/08

(X4)

10/03/08

(X4)

10/03/08

(X4)

10/03/08

(X4)

10/03/08

(X4)

10/03/08

(X4)

10/03/08

(X4)

200



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10/03/08

(X4)

10/03/08

(X4)

10/03/08

(X4)

10/03/08

(X4)

10/03/08

(X4)

10/03/08

(X4)

10/03/08 (4)

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



Packaging

Packaging

Identify as per dwg & Stock Location

PAP

0.00

Memo

56250

0.00

10/3/11 (4)

220



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/16
MF 10-3-11

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 56249

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2244-116



Step Extrusion

Manufactured

No

100

Each

20.5000

4.0000



10.02.24

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

20.5

20.5

38023

100

Each

29.0000

8.0000



4
10.02.24

D2561



Lug

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

29

53616

100

Each

19.0000

8.0000



8
10.02.24

D2564



Mounting Angle

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

19

47966

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 3/4/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2673-34



End Plate

Manufactured

No

100

Each

18.0000

4.0000



10.02.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

54361

18

150

Each

18.0000

4.0000



4
10.02.25

D2673-34



End Plate

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

54361

18

4

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Shop Packet Print

Page 2

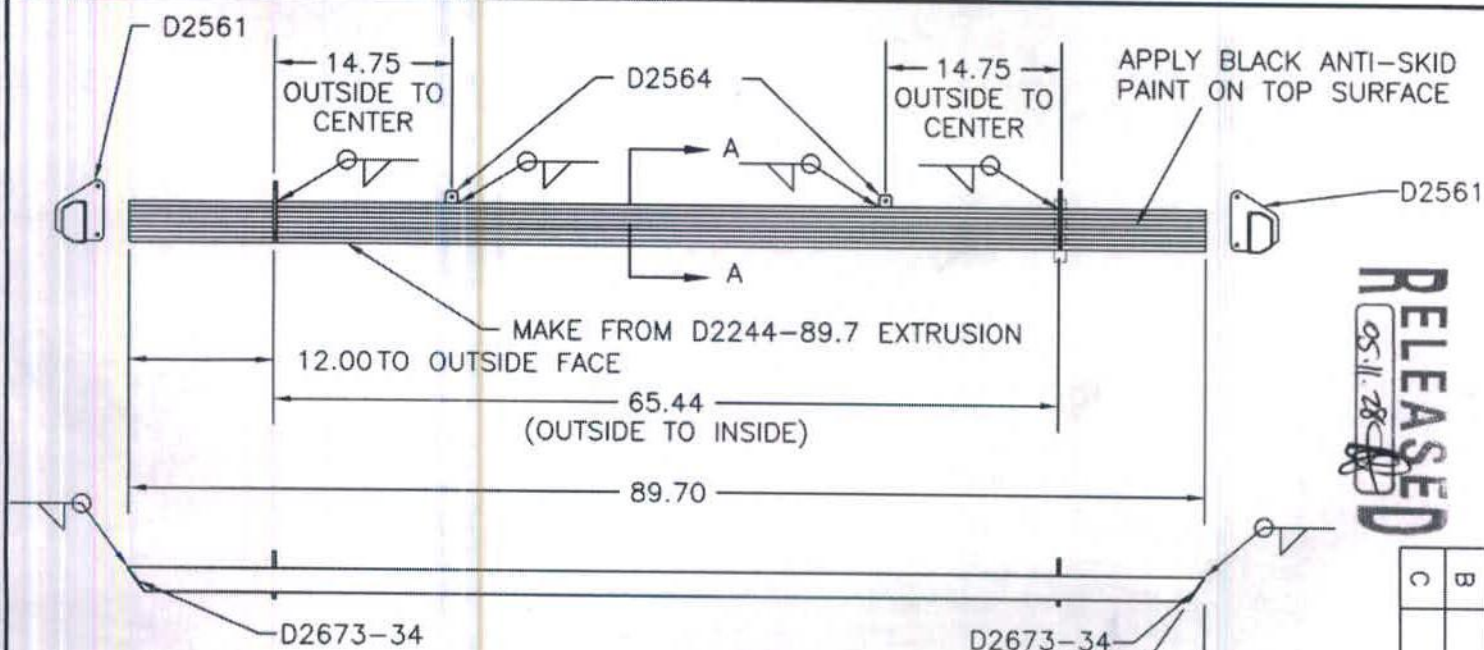
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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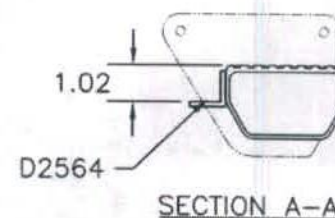
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DART**RELEASED**
05.11.28**D2563 STEP WELDMENT ASSEMBLY PARTS LIST**

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

**D2563 STEP WELDMENT ASSEMBLY NOTES**

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	DART AEROSPACE LTD
CHECKED		APPROVED	DRAWING NO.
DATE	05.11.14		D2563
			TITLE
			STEP WELDMENT ASSEMBLY
			SCALE
			1:15
			REV. C
			SHEET 1 OF 1
			DATE
			05.11.14
			NEW ISSUE
			END CAPS CHANGED (WAS D2248)
			UPDATE NOTES

